

Date: Wednesday, 1/11/2006 4:23:57 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	CONSOLE ASSEMBLY	
Job Number :	25446	Part Number :	D206547043	
Estimate Number :	11224	Drawing Number :	D206-547 REV F	
P.O. Number :	N/A	Project Number :	N/A	
This Issue :	1/11/2006	Drawing Revision :	F	
Prsht Rev. :	NC	Material :	N/A	
First Issue :	N/A	Due Date :	2/15/2006	Qty: 10 Um: Each
Previous Run :	25109	Type :	SMALL / MED FAB	
Written By :	SEE COMMENT BELOW			
Checked & Approved By :	SEE ABOVE USER & DATE			
Comment :	Est Rev: 06-01-05 Removed Packing Kit JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2024	Extrusion, Console
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w 0603-13



Comment: Qty.: 3.5910 Each(s)/Unit Total : 35.9100 Each(s)

D2024 Extrusion

Batch m1

ml 06/02/27

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT 8264-1, DT 8264-2, DT8264-3, DT8264-4

2-Deburr

ml 06/03/01

3.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

4.0	D26021	Console Side Hi Slope
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D2602-1	Side LH	B25471

5.0	D26022	Console Side Hi Slope
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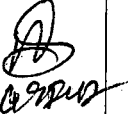
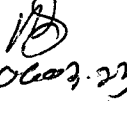

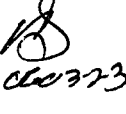
**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 1 Date: 06/04/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/03/23	4	2 part were damaged 1- D2602-1 1- D2607		Swap + replace it D2607 B 25143 D2602-1 B 23311	SB 06/03/23			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:23:57 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY

Job Number: 25446

Part Number: D206547043

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D2602-2

Side RH

25472

W 06/03/03

✓

6.0

D2606

Hi Console Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2606

Bracket

B25142 ⑦

B22763 ③

W 06/03/03

✓

7.0

D2607

Console Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2607

Bracket

B25473

W 06/03/03

8.0

MS20470AD33

Rivet, Universal Head



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 MS20470AD3-3

Rivet

M1065

✓

SB 06/03/03

9.0

MS20470AD34

Rivet, Universal Head



Comment: Qty.: 20.0000 Each(s)/Unit Total : 200.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

20 MS20470AD3-4

Rivet

M15541

W 06/03/03

✓

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

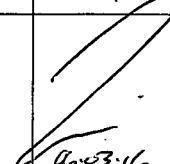
1-Grind weld relief chamfer as per Dwg D206-547

PTO

2-Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4

mlo6/03/03

⑩

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/03/03	10	The drw. of chamfer should be change. I grinded more than drw. as Qc said	ml	06/03/03			 06-03-16

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:23:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY

Job Number: 25446

Part Number: D206547043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



06-03-16

Comment: INSPECT WORK TO CURRENT STEP

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Tack weld as per Dwg D206-547

A/R AL ROD Batch: 118838

CPL 06-03-16

13.0

QC5/9

WELD INSPECTION



10

Comment: WELD INSPECTION

06/03/21

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3

SB 06/03/23 10

15.0

QC5

INSPECT WORK TO CURRENT STEP



06-03-23

Comment: INSPECT WORK TO CURRENT STEP

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

a.m 06-04-03 10

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06 04 03 10

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: — Phb

06/04/04 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:23:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY

Job Number: 25446

Part Number: D206547043

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/04/05 (70)

Job Completion



u d206547043

51

1000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D206-547	REV. F SHEET 1 OF 5
DATE 99.02.11		TITLE CONSOLE ASSEMBLY	SCALE NTS
-	82.11.23	NEW ISSUE	
A	83.01.18	REDRAWN, ADD NOTE 4	
B	84.10.23	D206-547 WAS 01.B.81.017	
C	89.03.30	REDRAWN	
D	90.12.06	COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85	
E	97.10.22	REDRAWN, ADD -043,-045,-047	
F	99.02.11	ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL	

RELEASED
99.03.05 RE

-041	-043	-045	-047	PART NUMBER	DESCRIPTION
X				D206-547-041	CONSOLE ASSEMBLY
	X			D206-547-043	CONSOLE ASSEMBLY
		X		D407-547-045	CONSOLE ASSEMBLY
			X	D407-547-047	CONSOLE ASSEMBLY
1				D2601-1	CONSOLE SIDE
1				D2601-2	CONSOLE SIDE
	1			D2602-1	CONSOLE SIDE
	1			D2602-2	CONSOLE SIDE
		1		D2603-1	CONSOLE SIDE
		1		D2603-2	CONSOLE SIDE
			1	D2604-1	CONSOLE SIDE
			1	D2604-2	CONSOLE SIDE
1		1		D2605	CONSOLE BRACKET
	1		1	D2606	CONSOLE BRACKET
1	1			D2607	CONSOLE BRACKET
		1	1	D2608	CONSOLE BRACKET
1		1		D2709-1	CONSOLE SIDE RAIL
1		1		D2709-2	CONSOLE SIDE RAIL
1		1		D2709-3	CONSOLE SIDE RAIL
1		1		D2709-4	CONSOLE SIDE RAIL
	1		1	D2710-1	CONSOLE SIDE RAIL
	1		1	D2710-2	CONSOLE SIDE RAIL
	1		1	D2710-3	CONSOLE SIDE RAIL
	1		1	D2710-4	CONSOLE SIDE RAIL
10	8	8	6	MS20470AD3-3	RIVET
18	20	18	20	MS20470AD3-4	RIVET

SHOP COPY
RET'URN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 25446



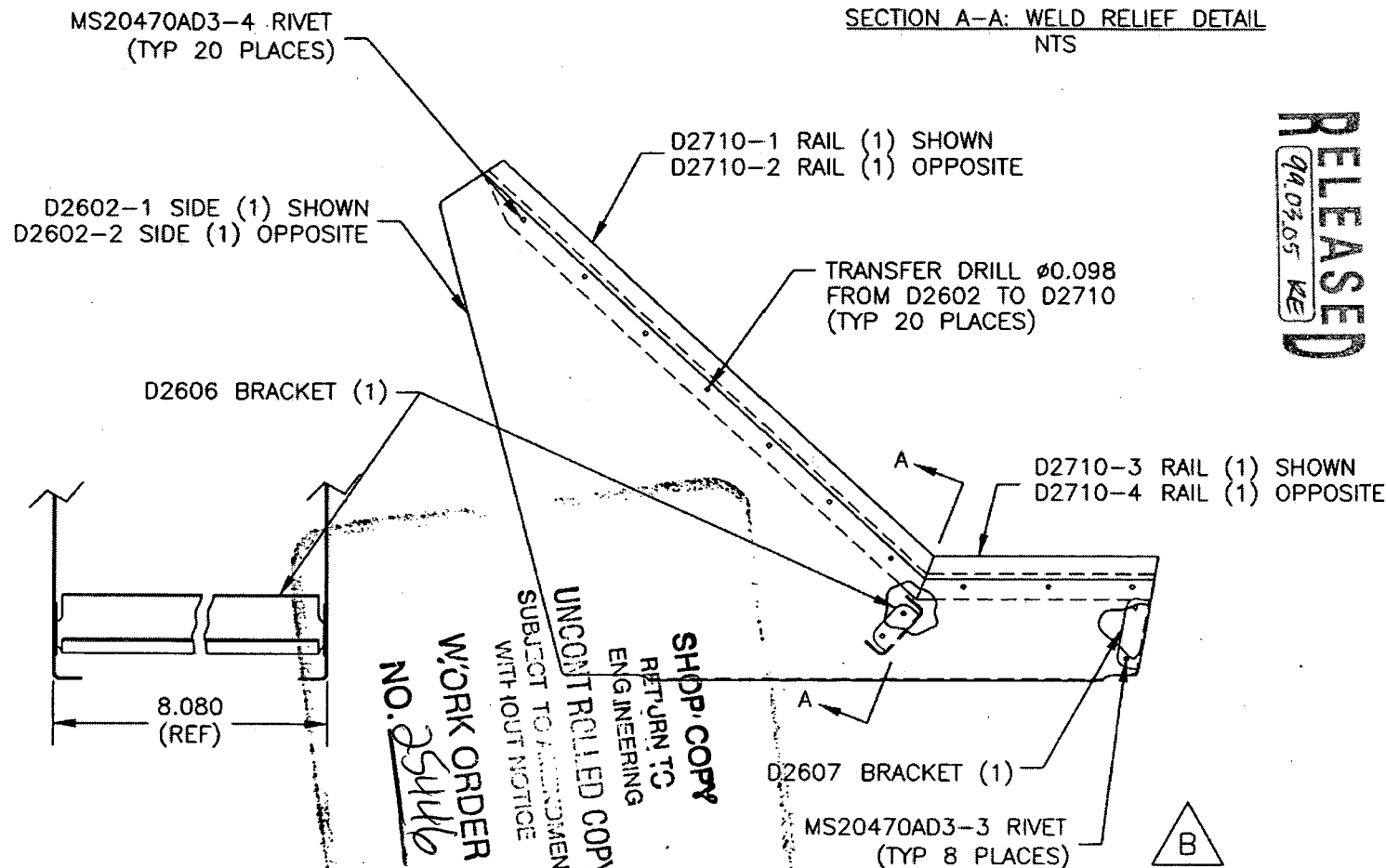
RELEASED
99.03.05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		
BW	RF	DRAWING NO.	REV. F	
CHECKED UP	APPROVED KE	D206-547	SHEET 3 OF 5	
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	SCALE 1:4		



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D206-547-043 (206 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Date: Wednesday, 1/11/2006 4:14:26 PM
 User: Kim Johnston

Process Sheet

6

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HIGH SLOPE CONSOLE INSTALLATION
Job Number : 25433	
Estimate Number : 11629	
P.O. Number :	Part Number : D206549013
This Issue : 1/11/2006 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number :
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : N/A
Previous Run : 25406	Material :
Written By :	Due Date : 2/7/2006 Qty: 10 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 06-01-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD206-549-013 CHG001

Feb. 20/06

(10)

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D2163	Angle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Qty Part Number Description Batch

1 D2163 Cap Angle

4.0	D206547043	Avionics Console
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Qty Part Number Description Batch

1 D206-547-043 Avionics Console

REFERENCE ONLY

5.0	D20654711	Angle, Console
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Qty Part Number Description Batch

2 D206-547-11 Angle, Console